

BLUE

Dart Aerospace Ltd.

23

Date: Wednesday, 5/16/2007 8:14:46 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER REVIEW  
 Job Number : 32385  
 Estimate Number : 10937  
 P.O. Number : N/A Part Number : D29392  
 This Issue : 5/16/2007 S.O. No. : N/A Drawing Number : D2939 REV C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : C  
 Previous Run : 30483 Material : N/A  
 Due Date : 6/6/2007 Qty: 16 Jm: Each  
 Written By :  
 Checked & Approved By : JF 07.05.16  
 Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC  
 Est Rev: C As per Rev C 07-03-19 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101001 7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0" x 6.25" X 6.00" Grain Along 6.00" Length

Batch No: B25345 JF 07/05/04

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

5-Deburr

J.F. 07/25/25 J.L. 07/05/04

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

Er 07/06/07

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.F./Er 07/06/07

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER  
REVIEW

Job Number: 32385

Part Number: D29392

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*07/06/09 16*

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*07-06-11 16*

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

-PRIME

-PAINT DELFLEET BLUE (PER QSI005)

-CLEAR DELFLEET

*Atelier Delassette*

*P.O. 4034 u 07-06-25 (1)*

8.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

*07-06-22*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*07/06/25 (1)*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07/06/25 (1)*

Job Completion



*u 07-06-25*

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>32385</b>
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b>	<b>D2939-2</b>
<b>Inspection Dwg:</b> D2939 Rev. C		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.116"	.116"	.114	.116		
B	0.100	0.140		.114"	.114"	.113	.115		
C	0.100	0.140		.117"	.117"	.117	.115		
D	0.210	0.230		.222"	.222"	.219	.219		
E	1.245	1.255		1.250"	1.250"	1.250	1.250		
F	1.245	1.255		1.250"	1.250"	1.250	1.250		
G	2.495	2.505		2.502"	2.501"	2.500	2.500		
H	0.510	0.515		0.511	0.511	0.511	0.511		
I	1.572	1.582		1.580"	1.580"	1.577	1.577		
J	2.495	2.505		2.500"	2.500"	2.500	2.500		
K	0.257	0.262		Ø.257"	Ø.257"	Ø.257"	Ø.257"		
L	0.312	0.317		Ø.312"	Ø.312"	Ø.312"	Ø.312"		
M	0.235	0.240		Ø.239"	Ø.239"	Ø.239"	Ø.239"		
N	0.100	0.140		.120"	.120"	.118	.118		
O	0.540	0.560		.550"	.552"	.551	.550		
P	0.490	0.510		.503"	.503"	.501	.498		
Q	3.715	3.725		3.721"	3.721"	3.720	3.720		
R	2.720	2.760		2.745"	2.745"	2.745	2.745		
S	0.240	0.270		.253"	.253"	.247	.250		
T	0.100	0.180		.140"	.140"	.140"	.140"		
U	1.625	1.635		1.630"	1.630"	1.630	1.630		
V	1.362	1.372		1.368"	1.368"	1.367	1.367		
W	0.316	0.321		Ø.318"	Ø.318"	Ø.318"	Ø.318"		
X	1.250	1.270		1.260"	1.259"	1.259"	1.260"		
Y	1.565	1.585	DT8695 A/B	1.575"	1.575"	1.575"	1.575"		
Z	0.178	0.198		R.188"	R.188"	R.188"	R.188"		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <b>JF / J.L</b>	Audited by: <b>gml</b>
Date: <b>07/05/25 / 07/05/26 / 07/06/07</b>	Date: <b>07/06/05</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	32385
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b>	D2939-2
<b>Inspection Dwg:</b> D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.115	.115	.118	.115		
B	0.100	0.140		.115	.115	.116	.115		
C	0.100	0.140		.118	.121	.120	.116		
D	0.210	0.230		.219	.218	.219	.219		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.511	0.511	0.511	0.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.315	.315	.315	.315		
M	0.235	0.240		.239	.239	.239	.239		
N	0.100	0.140		.117	.117	.116	.119		
O	0.540	0.560		.550	.550	.551	.549		
P	0.490	0.510		.501	.501	.500	.498		
Q	3.715	3.725		3.719	3.720	3.720	3.720		
R	2.720	2.760		2.745	2.745	2.745	2.745		
S	0.240	0.270		.250	.250	.249	.249		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.320	.320	.320	.320		
X	1.250	1.270		1.260	1.258	1.260	1.262		
Y	1.565	1.585	DT8695 A/B	1.575	1.575	1.575	1.576		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L.
Date:	07/05/26 / 07/06/07

Audited by:	J.W.
Date:	07/06/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 32385
<b>Description:</b> 206 Saddle, Inboard, Right side		<b>Part Number:</b> D2939-2
<b>Inspection Dwg:</b> D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.119	.118	.118	.118		
B	0.100	0.140		.119	.119	.117	.118		
C	0.100	0.140		.120	.130	.120	.120		
D	0.210	0.230		.218	.219	.220	.218		
E	1.245	1.255		1.250	1.250	1.249	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.511	0.511	0.511	0.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.499	2.500	2.499		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.315	.315	.315	.315		
M	0.235	0.240		.239	.239	.239	.239		
N	0.100	0.140		.119	.119	.119	.117		
O	0.540	0.560		.550	.551	.551	.550		
P	0.490	0.510		.501	.501	.502	.501		
Q	3.715	3.725		3.719	3.719	3.720	3.720		
R	2.720	2.760		2.745	2.745	2.745	2.745		
S	0.240	0.270		.249	.248	.250	.248		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.320	.320	.320	.320		
X	1.250	1.270		1.262	1.261	1.260	1.261		
Y	1.565	1.585	DT8695 A/B	1.576	1.576	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JL
Date:	07/05/06 / 07/06/07

Audited by:	JML
Date:	07/06/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	32385
<b>Description:</b> 206 Saddle, Inboard, Right side		<b>Part Number:</b>	D2939-2
<b>Inspection Dwg:</b> D2939 Rev. C		Page 1 of 1	

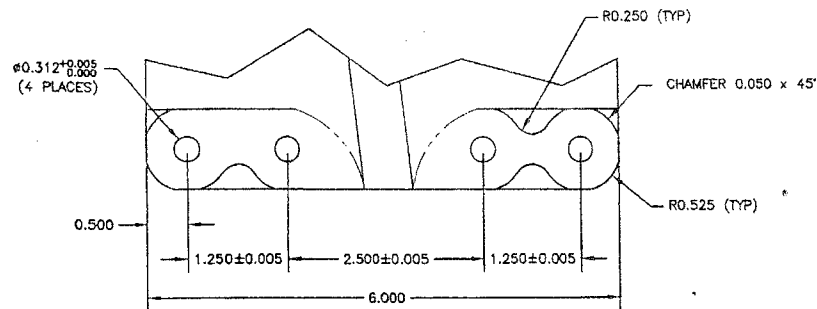
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B	0.100	0.140		.119	.120	.119	.120		
C	0.100	0.140		.120	.118	.120	.120		
D	0.210	0.230		.219	.219	.220	.219		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.249	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.511	0.511	0.511	0.511		
I	1.572	1.582		1.574	1.574	1.574	1.574		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.315	.315	.315	.315		
M	0.235	0.240		.239	.239	.239	.239		
N	0.100	0.140		.118	.118	.119	.120		
O	0.540	0.560		.549	.550	.548	.548		
P	0.490	0.510		.502	.500	.501	.500		
Q	3.715	3.725		3.719	3.720	3.720	3.720		
R	2.720	2.760		2.745	2.745	2.745	2.745		
S	0.240	0.270		.250	.250	.249	.249		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.320	.320	.320	.320		
X	1.250	1.270		1.261	1.260	1.260	1.262		
Y	1.565	1.585	DT8695 A/B	1.575	1.575	1.575	1.576		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L.
Date:	07/05/27 / 07/06/07

Audited by:	[Signature]
Date:	07/06/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	[Signature]

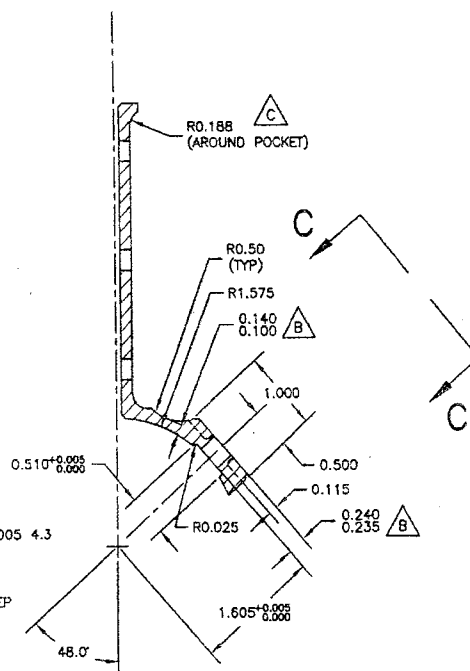


VIEW C-C

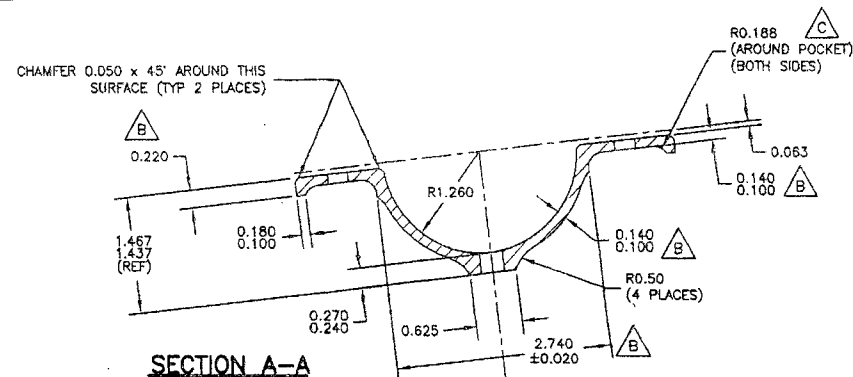
D2939-1 LH SADDLE (SHOWN)  
D2939-2 RH SADDLE (OPPOSITE)

NOTES:

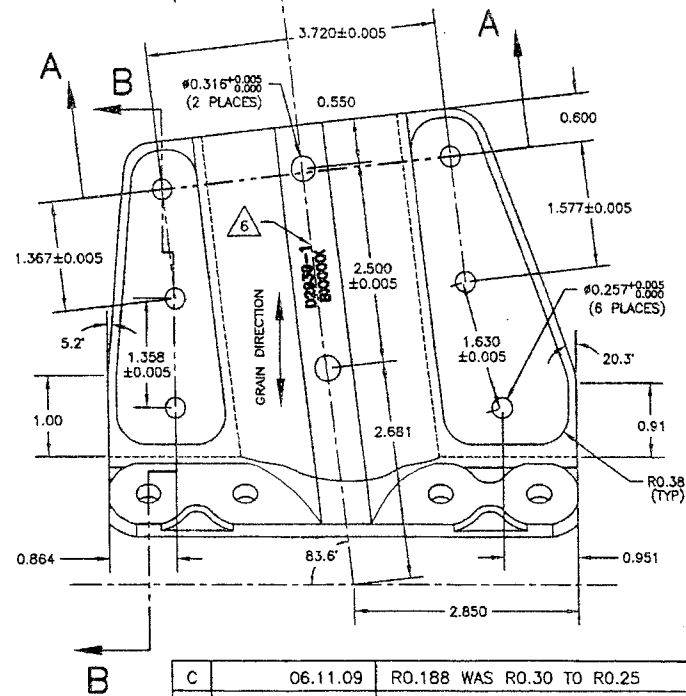
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC.
CHECKED	APPROVED	DRAWING NO. D2939
DATE	TITLE	SADDLE INSIDE
06.11.09		2:3

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